

Date: Tuesday, 03/06/2008 1:03:23 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	R44 BEARPAW
Job Number :	39667A		
Estimate Number :	12480		
P.O. Number :		Part Number :	D35291
This Issue :	03/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3529 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	38021A	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<u>JUD 08-6-03</u>	Due Date :	20/06/2008
Comment :	Est Rev:A New Issue 06-06-28 JLM	Qty:	8 ^{PCS.} Um: Each

Not 8 sets

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 1.3283 sf(s)/Unit Total : 10.6260 sf(s)
 Pick:
 blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000)
 Material: Black UHMW 1"(MUHMWB10)
 Batch: M108013

M.A 08/06/04

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING
 Program Batch Number

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

M.A/JL 08/06/09

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A/JL 08/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/06/2008 1:03:23 PM
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Drawing Name: R44 BEARPAW

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/06/10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 39667

P 8/7/01

4 hit

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/02

Job Completion



MF 08-07-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 3966 FA
Description: Bearpaw		Part Number: D3529-1
Inspection Dwg: D3529	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.50	✓			
B	0.07 x 45°	+/-0.030 x 0.5°	0.040	✓			
C	R0.25	+/-0.030	R0.25	✓			
D	0.250	+/-0.010	0.240	✓			
E	0.625	+/-0.010	0.622	✓			
F	0.950	+/-0.010	0.949	✓			
G	1.63	+/-0.030	1.620	✓			
H	12.14	+/-0.030	12.140	✓		tape	
I							
J	5.70	+/-0.030	5.710	✓			
K	0.375	+/-0.010	0.369	✓			
L	0.525	+/-0.010	0.519	✓			
M	0.13 x 45°	+/-0.030 x 0.5°	0.130 x 45°	✓			
N	R0.50	+/-0.030	R0.50	✓			
O	12.76	+/-0.030	12.76	✓		tape	
P	3.38	+/-0.030	3.373	✓			
Q	3.75	+/-0.030	3.375	✓			
R	5.187	+/-0.010	5.190	✓			
S	5.25	+/-0.030	5.252	✓			
T	7.13	+/-0.030	7.128	✓			
U	Ø0.260	+0.006/-0.001	Ø0.260	✓			
V	0.30	+/-0.030	0.300	✓			
W	0.93	+/-0.030	0.928	✓			
X	1.30	+/-0.030	1.271	✓			

Measured by: M.A.	Audited by: J.F.	Prototype Approval:	N/A
Date: 08/06/09	Date: 08/06/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

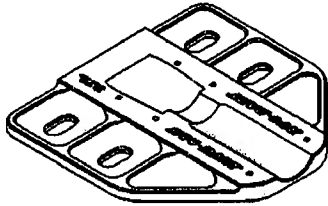
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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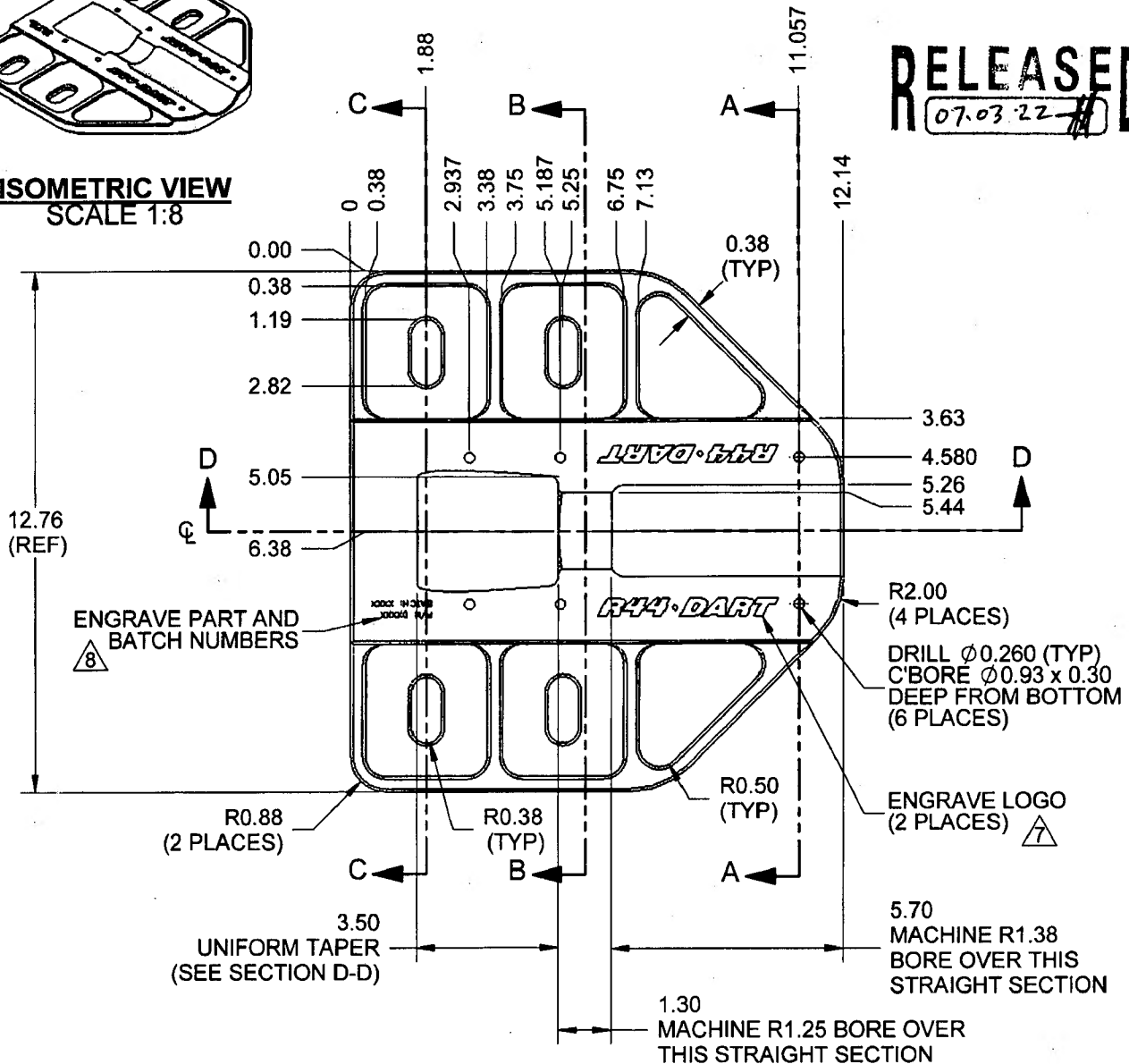
NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT \varnothing
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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WITHOUT NOTICE

WORK ORDER

NO. 3866717

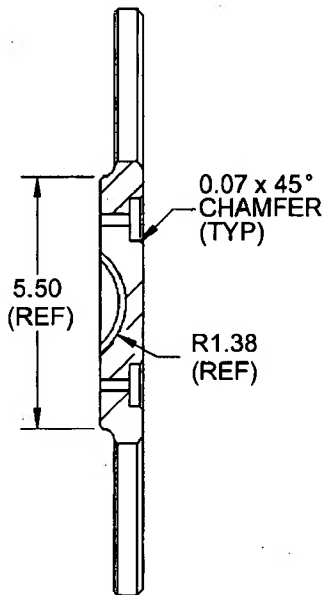
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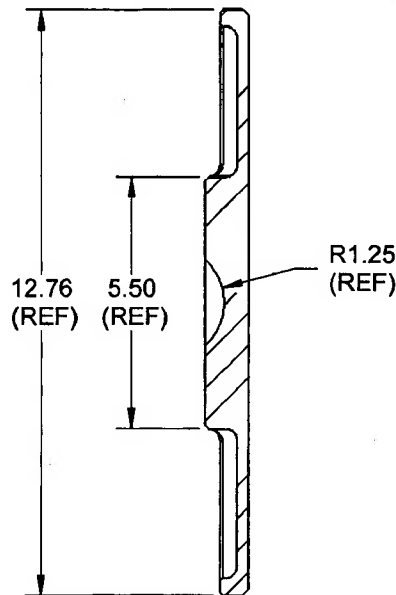


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

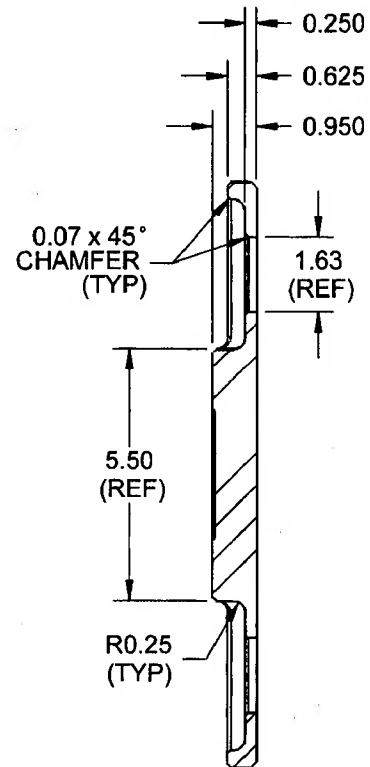
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07.03.22



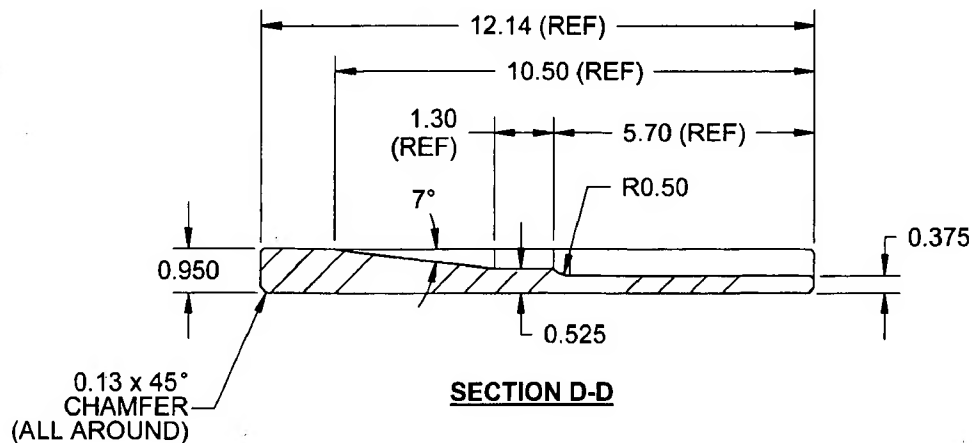
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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